



Dart Aerospace Ltd.
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D350-600-249
Job Sheet 201014



Part No: D350-600-249

Job Qty: 2 pcs

Part Name: Spacepod™ Fwd Opening Upgrade Hardware Only



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/20/19

Job Tracking No:

Due Date: 9/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 19720

Note: D350-600 rev.E IPP Rev:A new issue 07.01.31 EC IPP Rev:B 11.02.07 added missing AN960JD8 washer DD
verf:JLM IPP REV:A 11.04.27 added 1 D3554-7 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs		9/30/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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Container No: S219379

Part: D350-600-249

Job No: 201014

Serial No/Batch: S219379

Revision: E

Inspector:

Exp Date:

Instructions: TC STC SH93-88 issue 6-01-FA-0073, SR000981

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120 QC 4	2 pcs	9/30/19	0.00 0.00	Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	DAS
				QC 4 - 75	78
130 Packaging 3-1 - Stock - B4B 2 pcs		9/30/19	0.00 0.00		9-89
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	DAS
				Packaging 3 - 26 - B4B	78
				Packaging 3 - 27 - B4B	9-89
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	2 pcs	9/30/19	0.00 0.00	DC - 1 - B4B	DAS
				DC - 2 - B4B	21
140 QC 21 - FG	2 pcs	9/30/19	0.00 0.00	QC 21 - FG - 21	9-89
				QC 21 - FG - 70	DAS
				QC 21 - SA - 53	21

Part Op 110 - Packaging

Descriptions: 120 - (QC4- 100% Inspect kits for completeness)

130 - Identify and pack for shipping as per PPP D350-600-249 Location: _____ PPP Rev: _____

135 - (Document Control) Photocopy bluefile & type labels per PPP 350-600-249 CHG002
 140 - (QC21- Final Inspection - Work Order Release)

012233

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
A3235-020-935	Washer, Countersunk	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	FM134970
AN5-5A	Bolt	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	FM133363
AN526C832R10	Screw	20 Ea (10 ea)	110-Packaging 1 - Pick Kit	M137851
AN526C832R14	Screw	12 Ea (6 ea)	110-Packaging 1 - Pick Kit	FM133932
AN526C832R24	Screw	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	F124255
D2228	Backing Plate	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	E105984
D2237	Striker Plate	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S216874
D2484	Neoprene Seal (\$Per Foot)	6 ft (3 ea)	110-Packaging 1 - Pick Kit	S131946
D3015-3	Locknut	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	S152544
D3538-1	Hinge Bracket	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	S122104
D3547-1	Bracket	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	F106211
D3550-1	Strut	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	F113713
D3552-7	Door Prop	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S172542
D3554-7	Ball Stud	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	S163145
D3557-1	Bracket	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	F126308x1 S218303x1
D5127-1	Shim, Large	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	S160864
D5127-3	Shim, Small	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	S160862
MS20426AD4-5	Rivet	4 Ea (2 ea)	110-Packaging 1 - Pick Kit	S185056
MS21042L08	Nut	44 Ea (22 ea)	110-Packaging 1 - Pick Kit	S205000
MS21042L3	Nut	4 Ea (2 ea)	110-Packaging 1 - Pick Kit	S211533
MS21042L5	Nut	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	S208332
MS24694-S69	Screw	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	F112492
MS27039-08-11	Screw	4 Ea (2 ea)	110-Packaging 1 - Pick Kit	M138336
MS27039-1-25	Screw	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	FM127432
NAS1149D0332J	Washer	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	S209100
NAS1149D0363J	Washer	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	S201031
NAS1149D0563J	Washer	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	S174288
NAS1149DN832J	Washer	48 Ea (24 ea)	110-Packaging 1 - Pick Kit	S185074
NAS1515H3	Washer	4 Ea (2 ea)	110-Packaging 1 - Pick Kit	FM131697-25

DAS
40
8-89
GA 127

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	A3235-020-935	2	67	0
	AN5-5A	2	93	0
	AN526C832R10	20	62	0
	AN526C832R14	12	86	0
	AN526C832R24	8	26	0
	D2228	4	6	0
	WT- D2237	2	5	0
	D2464	6	508	0
	D3015-3	4	134	0
	D3538-1	4	8	0
	D3547-1	2	9	0
	D3550-1	2	4	0
	D3552-7	2	7	0
	D3554-7	4	22	0
	WT- D3557-1	2	1	0
	D5127-1	4	9	0
	D5127-3	4	9	0
	MS20426AD4-5	4	78	0
	MS21042L08	44	734	0
	MS21042L3	4	1,726	0
	MS21042L5	2	388	0
	MS24694-S69	2	27	0
	MS27039-08-11	4	1,012	0
	MS27039-1-25	2	63	0
	NAS1149D0332J	2	1,778	0
	NAS1149D0363J	2	664	0
	NAS1149D0563J	8	1,296	0
	NAS1149DN832J	48	936	0
	NAS1515H3	4	221	0

Part Specifications

Specifications could not be found.

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Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

[illegible]

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3I-4 SPACEPOD™ DOOR

** PRE-INSTALLED ON D3188-5I-6I-7 SPACEPOD™

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: **E**

Date: 09.07.31

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-600 REV E AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-600 REV 5

REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY and SR00099NY
REF. EASA STC EASA.IM.R.S.01292

1.0 PURPOSE

In response to customer feedback, Dart is implementing changes designed to ease the mounting of hinge brackets for the forward opening Spacepod and to improve the security of the hinge assemblies. The purpose of this DSI is to introduce the DSI 9701-011 Hinge Shim Kit and to provide instructions and parts lists to install and assemble the hinges on Dart Spacepods D350-600-241/-242/-243/-247/-248/-249. One Kit is required per door.

2.0 PROCEDURE

- 2.1 Remove the D3188-3/-4 Spacepod Door by disconnecting the hinges.
- 2.2 Remove the D3538-1 Hinge Brackets and D2179 Hinge Bracket Plates. Retain all parts.
- 2.3 Re-install the D3538-1 Hinge Brackets with the D5127-3 Shims between the Spacepod and Hinge Bracket using the existing mounting holes and fasteners. See Figure 1. The D3538-1 Hinge Brackets should be oriented as per Table 1. It may be necessary to reverse the orientation, as required, on some Spacepod bodies. Furthermore, due to normal variations in the Spacepod geometry, additional shimming may be required. It is acceptable to use Hysol Liquid Shim, thin washers or shims fabricated from 6061-T6 aluminum for this purpose.
- 2.4 Torque fasteners to 9-12 In-lbs (1-1.4 N-m).

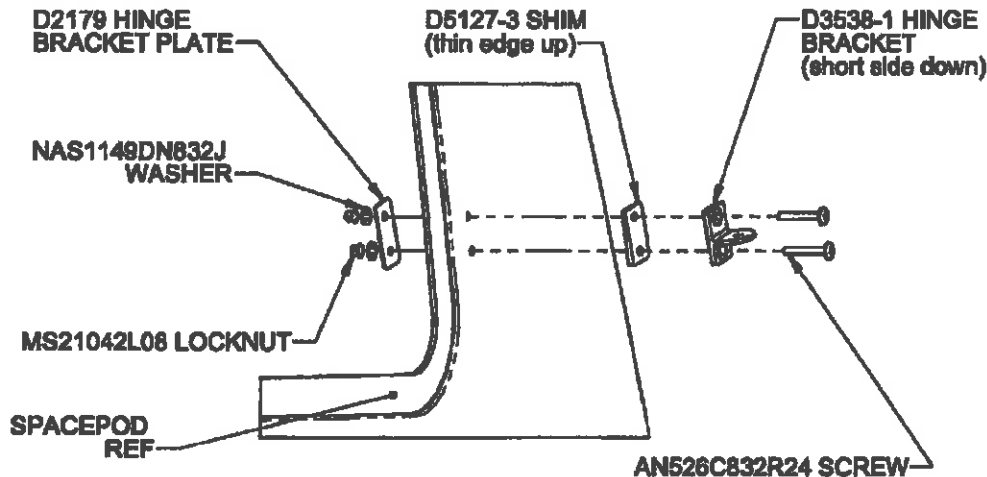


FIGURE 1: SPACEPOD HINGE INSTALLATION
(LOWER HINGE, RH DOOR SHOWN)

SPACEPOD	UPPER D3538-1 BRACKET	LOWER D3538-1 BRACKET
RIGHT SIDE	SHORT SIDE UP	SHORT SIDE DOWN
LEFT SIDE	SHORT SIDE DOWN	SHORT SIDE UP

TABLE 1: D3538-1 HINGE ORIENTATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY:
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

B	ADD NOTES ALLOWING USE OF ADDITIONAL SHIM MATERIALS, ALTERNATE SHIM ORIENTATION	DB	14.09.09
A	NEW ISSUE	DB	14.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	13	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9701	SHEET 1 OF 3
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	HINGE SHIM KIT	NTS
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